

slip 5m 1b

Work Order ID 78090

78090

Page 1

December-28-11 3:30:33 PM

Item ID: D3828-1KGY

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Vertical Tunnel Lower, LH

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: M.C.J.

Date: 11/12/28

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3828

A

100

0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x/

OK
12/01/09

105

0.00

105

HandThermo

Dry material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

x/

OK
12/01/09

Temp: 150°F

Time IN: 7:00pm 12/01/08

Time OUT: 5:00am 12/01/09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78090

Page 2

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

*** 1 ***

Cust Item ID:

*** 1 ***

Customer:

Reference:

Run Start *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

110

0.00

110

0.00

Thermoform

Thermoforming Machine

Memo

1-Machine Set-Up

2-Pre-heat Tool to required temp.

3-Thermoform as per Dwg and Folio #FTA052 using tool DT9228

Dwg Rev: **A**

Folio Rev: C

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

0.00

OC

Quality Control

Memo

Visually inspect part for proper formation and texture

130

QC8- Inspect parts - second check

0.00

130

0.00

QC

Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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78090

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N900040100

Stop ***NS2***

Reference:

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

140	0.00	
-----	------	--

0.00

1-Trim to finished dimensions as per Dwg

150	QC2- Inspect parts off machine FAI/FAIB	0.00	-
-----	---	------	---

0.00

Complete FAI document

160	QC5- Inspect part completeness to step on W/O	0.00	
-----	---	------	--

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Work Order ID 78090

December-28-11 3:30:33 PM

78090

Page 4

Item ID: D3828-1KGY

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Vertical Tunnel Lower, LH

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

Identify as per dwg & Stock Location: _____

0.00

170

Packaging

Memo

0.00

Packaging

12/1/16

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/1/16
me
12-01-16

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

December-28-11 3:30:37 PM

Page 1

Work Order ID: 78090

78090

Parent Item: D3828-1KGY

D3828-1KGY

Parent Item Name: Vertical Tunnel Lower, LH

Start Date: 28/12/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

Ipp Rev. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MKYD6185S.080-P3-52068		Purchased		No			sf	1,011.893		2.7083			

MKYD6185S 080-P3-52068

Kydex steel grey

**

Location

therm

111807

119476

Loc Qty

1011.893107

10.4896282

1001.40348

Loc Code

2.7083 sq ft

12/01/11

W/O:		WORK ORDER CHANGES					
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DART AEROSPACE LTD		Work Order:	78096
Description: Vertical Tunnel, Lower LH		Part Number:	D3828-1KIV/KGY
Inspection Dwg: D3828	Rev: A	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than $\frac{1}{8}$ "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: DR

Date: 12/01/09

TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.7	Ref	18.7 ¹¹	✓		TAPE DL-01	
7.3	Ref	7.375 ⁴	✓		TAPE DL-01	
4.5	Ref	4.6 "	✓		TAPE DL-01	
1.0	+/-0.100	1.07 "	✓		Scal DL-02	
0.9	+/-0.100	0.962 "	✓		Scal DL-02	
0.5	+/-0.100	0.583 "	✓		Scal DL-02	
0.050	Min	0.083 "	✓		ULTRA	

Measured by: DR

Date: 12/01/10

Audited by: S

Date: 12/01/10

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	11.01.17	New Issue	KJ	11.02.18

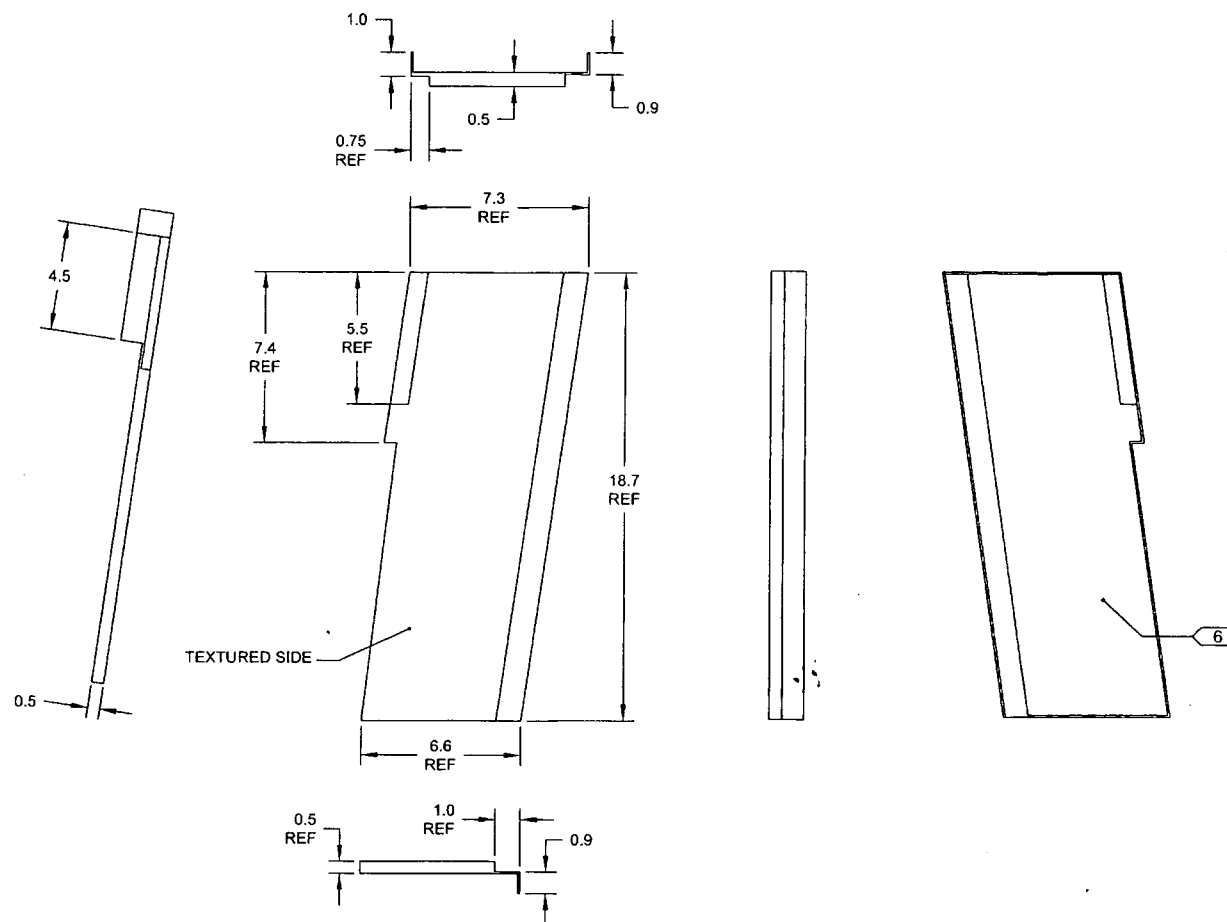
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



SHOP COPY
RETURN TO
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SUBJECT TO ANY
WITHOUT
WORK ORDER
NO. 78090 M.C.J.
11/12/28

RELEASED
09/08/25/14

D3828-1 VERTICAL TUNNEL, LOWER L/H

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9228 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3828-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3828-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.12
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.12		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. REV. A
D3828 SHEET 1 OF 2
TITLE SCALE
VERTICAL TUNNEL (206 L/L1/L3/L4) NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

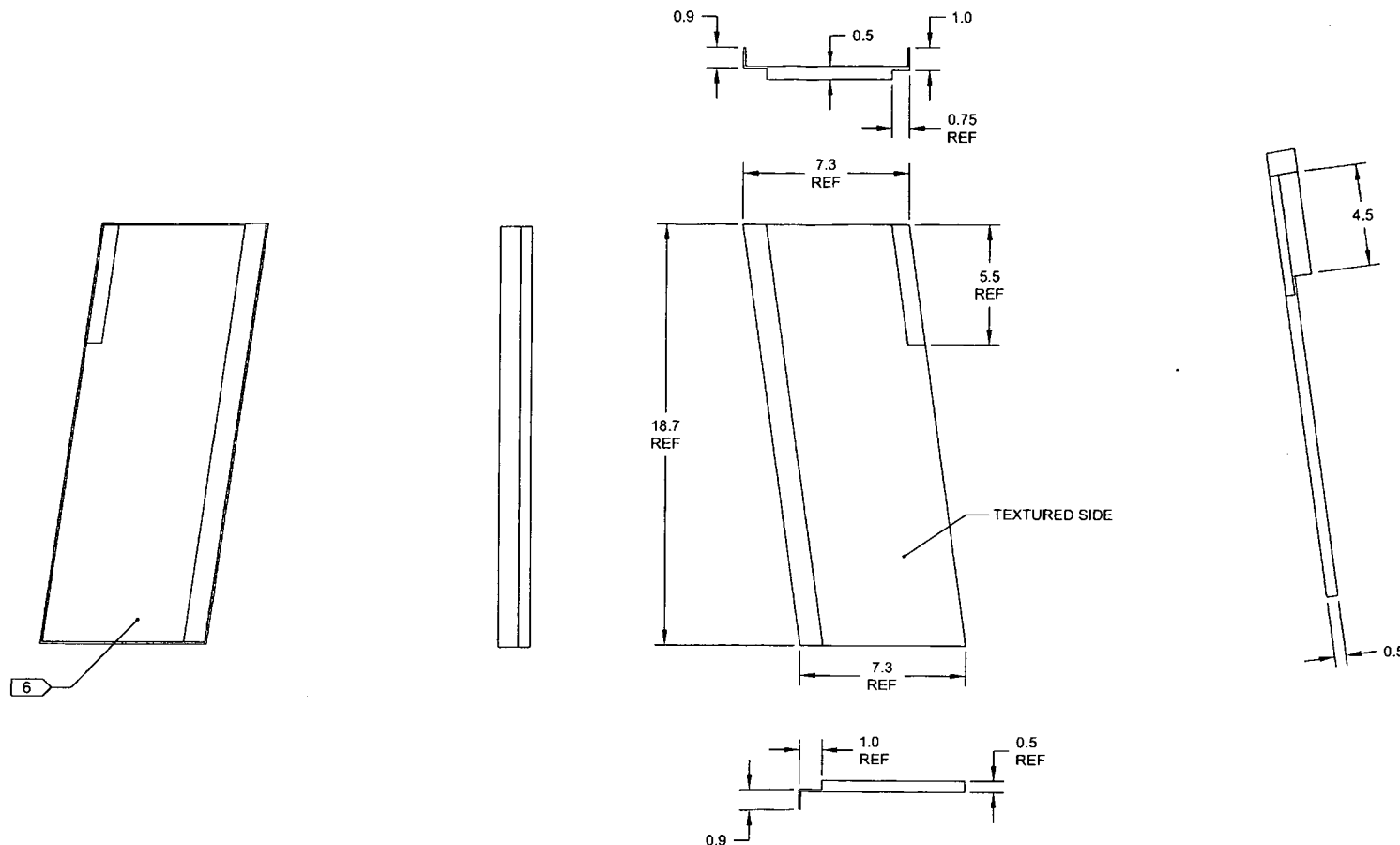
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

78090



D3828-2 VERTICAL TUNNEL, LOWER R/H

RELEASED
09/06/12

NOTES:

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.6 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9229 PER DART QSI 022. TRIM PER MOLD.
- 9) MINIMUM THICKNESS: 0.050" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3828-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3828-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.06.12		
		DRAWING NO.	REV. A
		D3828	SHEET 2 OF 2
		TITLE	SCALE
		VERTICAL TUNNEL (206 L/L1/L3/L4)	NTS
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